

March 29, 2010 8:49:38 AM



**Accept**

**Setup Start**

Revision ID:

**Item Name:** Spacer Bushing

**Stop**



**Start Date:** 29/03/2010      **Start Qty:** 20.00

**Cust Item ID:**

**Required Date: 05/04/2010    Req'd Qty: 20.00**



**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date: 10-3-25

### Tooling:

Date:

Run Start



**QC:**

Date:

**SPC (Y/N):**

Date:

**Stop**



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2327	Rev D								
100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	<b>Memo</b>	0.00							
Hardinge CNC Lathe Small	Turn per Folio FA232 and Dwg D2327 <input type="checkbox"/> Debur		SL	10/03/30			(20)		
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	<b>Memo</b>	0.00							
Quality Control			SL	10/03/30					
120		0.00							
	QC8- Inspect parts - second check								
QC	<b>Memo</b>	0.00							
Quality Control			S.F	10/03/30			(20)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57186

March 29, 2010 8:49:38 AM



Page 2

Item ID: D2327-3

Accept



Setup Start



Revision ID:

Item Name: Spacer Bushing

Stop



Start Date: 29/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 05/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location Basket

0.00



Packaging

Memo

0.00

Packaging

(2)

PD 10.03.30

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/31

10-3-31  
60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 29, 2010 8:49:43 AM

Page 1

Work Order ID: 57186



Parent Item: D2327-3



Parent Item Name: Spacer Bushing

Start Date: 29/03/2010

Required Date: 05/04/2010

Comments: IPP F05.11.02 Removed 303 SS KJ/EC

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	32.0151	3.2905			



304 ROUND BAR 0.375

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT029

32.0150579

112058

0.01317895

112473

9.6003

113325

22.4015789

- 3.3 SL 10/03/30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	57184
<b>Description:</b> Spacer Bushing		<b>Part Number:</b>	D2327-3
<b>Inspection Dwg:</b> D2327 <b>Rev:</b> D		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	375	✓			
Ø0.257	+0.005/-0.000	.257	✓			
1.750	+/-0.010	1.746	✓			

<b>Measured by:</b> SL	<b>Audited by:</b> SB	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/03/30	<b>Date:</b> 10/03/30	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	DA

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

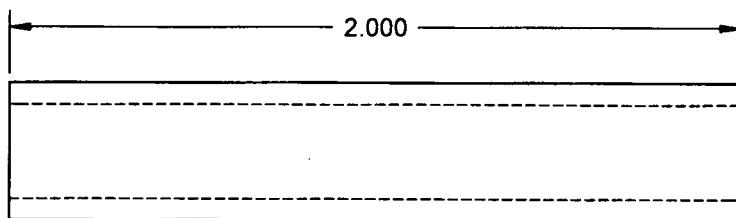
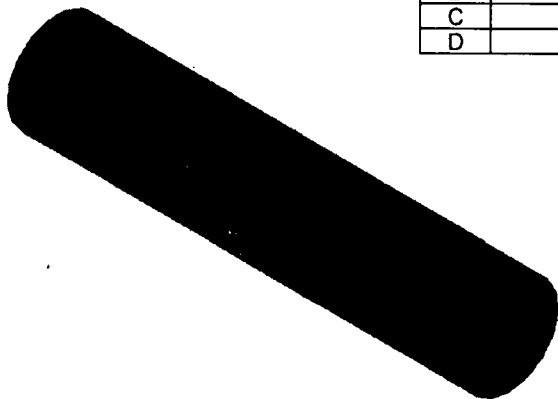
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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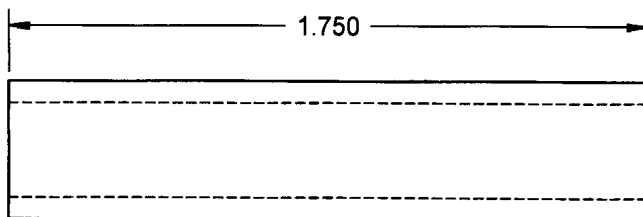
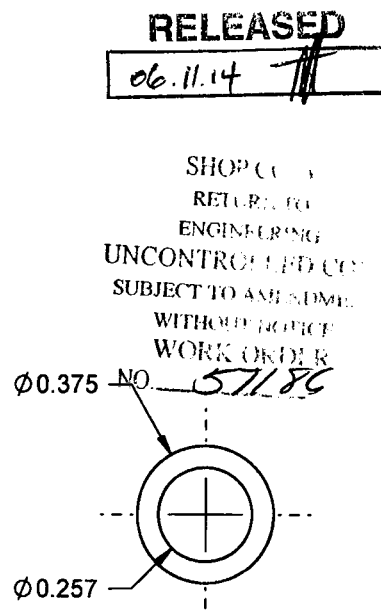




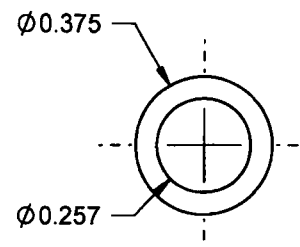
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



**D2327-1 SPACER BUSHING**



**D2327-3 SPACER BUSHING**



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING  
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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